

Work Order ID 60420

July 7, 2010 11:24:20 AM



Page 1

Item ID: D412-698-012

Accept



Setup

Start



Revision ID:

Item Name: Cabin Door Roller, RH

Stop



Start Date: 7/07/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/7/10 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

S 10/27/15

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-7-9 S/P (10)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

C 10/27/15

(70)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-698-012

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Accept



Setup Start



Item Name: Cabin Door Roller, RH

Stop



Start Date: 7/07/10 Start Qty: 1.00



Required Date: 7/14/10 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-012 Location: <u>Q2</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

REUB

10-7-16

SP

P

MSF
10-7-16

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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12

Work Order ID: 60420

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS
IPP Rev: D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141 Bracket Assembly		Manufactured	No			110	Each	6.0000	3	3		10-7-95	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235A		6							
				58541		6							
D3121-144 Bracket Assembly		Manufactured	No			110	Each	3.0000	1	1		10-7-95	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235A		3							
				58768		3							
D3137-043 Bracket Assembly		Manufactured	No			110	Each	9.0000	1	1		10-7-95	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235B		9							
				42192		3							
				59916		6							
D3183-044 Bracket Assembly		Manufactured	No			110	Each	2.0000	1	1		10-7-95	92
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST236		2							
				54760		2							

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 60420

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 1.00

Required Qty: 1.00

D3199-1

Manufactured No

110

Each

6.0000



Bracket

Location

Loc Qty

Loc Code

ST236A

6

56824

6

D3202-1

Manufactured No

110

Each

5.0000



Cover

Location

Loc Qty

Loc Code

ST241A

5

50134

5



9' 60066 Le 10/7/10

10-7-95/10

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Setup

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Revision ID:

Stop



Item Name: Cabin Door Roller, RH

Start Date: 7/07/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: *CZ*

Date: *10/7/17* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

CZ 10/7/18

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

REFERENCE ONLY

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01